

Work Order ID 130547

Thursday, April 02, 2015 9:20:30 AM

130547

Page 1

Item ID: D350-607-431

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut Retrofit

Stop ***NS2***

Start Date: 3/16/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/17/2015 Req'd Qty: 2.00

2

Customer: CHAWK02

Reference: RMA RA111954

Approvals: Process Plan: mfDate: 15-4-02

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9699	A								
IIN-D350-607-4	C								

100

0.00

100

QC

0.00

Quality Control

Memo

INSPECT RA111954

D350-607-431 X 2 B123639

ONE KIT IS GOOD AND CAN BE PACKAGED UP

OTHER KIT IS MISSING :

AN4-14A X12

AN4-42A X 4

AN6-13A X 2

MS21042L4 X 16

MS21042L6 X 2

NAS1149F0432P X 24

NAS1149F0663P X 4

ADD TO COMPLETE SECOND KIT

ID AND STOCK UNDER NEW BATCH NUMBER

ADD NEW PAPERWORK

APR 09 2015

DAB
06
9-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation		Disposition		Completed By																	
Root Cause		FAULT CATEGORY																			
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OTHER :																					

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Page 2

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Retrofit

Start Date: 3/16/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/17/2015 Req'd Qty: 2.00

2

Customer: CHAWK02

Reference: RMA RA111954

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

27

3-30

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS

05

3-30

2

APR 09 2015

130

Identify as per dwg & Stock Location: F6/28

0.00

130

Packaging

Memo

0.00

Packaging

2

APR 09 2015

DAS

05

3-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 150410

15-4-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 130547

130547

Parent Item: D350-607-431

D350-607-431

Parent Item Name: Strut Retrofit

Start Date: 3/16/2015

Required Date: 3/17/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.30 NEW ISSUE DD VERF: RQ IPP
REV:B 14.02.03 D350-607-4 REV.C DD VERF:JLM IPP REV:C
14.06.10 AS PER ECN14-572 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No				Each	260.0000		12		DAS 27 9-89	DAS 9 9-89
AN4-14A									**			APR 07 2015	
Bolt													

DAS
66
9-89

Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST325A	240	
131677	35	
M131153	5	
M131803	200	
ST344	15	
M130716	15	

12

AN4-42A		Purchased	No				Each	60.0000		4		DAS 27 9-89	DAS 9 9-89
AN4-42A									**			APR 07 2015	
Bolt													

DAS
66
9-89

Location	Loc Qty	Loc Code
ST312A	60	
M131320	60	

4

AN6-13A		Purchased	No				Each	38.0000		2		DAS 27 9-89	DAS 9 9-89
AN6-13A									**			APR 07 2015	
BOLT													

DAS
66
9-89

Location	Loc Qty	Loc Code
ST334	38	
m131305	38	

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Parent Item: D350-607-431

D350-607-431

Parent Item Name: Strut Retrofit

Start Date: 3/16/2015

Required Date: 3/17/2015

Start Qty: 2.00

Required Qty: 2.00

D350-607-431

Manufactured No

Each

2.0000

2

D350-607-431

Strut Retrofit

Location

Loc Qty

Loc Code

FG128

2

125766

2

Each

2,422.000

16

MS2104214

Purchased No

MS210421 4

Locknut

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

634

m127813

634

ST260a

1056

m130799

56

m131803

1000

ST305

690

426

426

m128300

8

m128798

10

m130922

97

m131340

137

m131618

12

DAS
08
9-89

DAS
27
9-89

DAS
9
9-89

APR 07 2015

2 x 123639 MUF
15-4-02

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, April 02, 2015 9:20:29 AM

Page 3

Work Order ID: 130547

130547

Parent Item: D350-607-431

D350-607-431

Parent Item Name: Strut Retrofit

Start Date: 3/16/2015

Required Date: 3/17/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L6

Purchased

No

Each

407.0000

2

MS21042L6

Nut

**

DAS

DAS

27

9

9-89

9-89

APR 07 2015

DAS

06

9-89

Location

Loc Qty

Loc Code

ST273A

200

m131624

200

ST305

7

m129909

1

m130799

6

t260a

200

m131317

200

Each

1,332.000

24

**

DAS

27

9-89

DAS

9

9-89

APR 07 2015

NAS1149F0432P

Purchased

No

NAS1149F0432P

WASHER

DAS

06

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M131697

1000

st268

332

M128995

63

M130388

8

M131340

261

Each

149.0000

4

**

DAS

27

9-89

DAS

9

9-89

APR 07 2015

NAS1149F0663P

Purchased

No

NAS1149F0663P

WASHER

DAS

06

9-89

Location

Loc Qty

Loc Code

st268

149

M128591

2

M13131

147

Thursday, April 02, 2015 9:20:29 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

RA111954 D350-607-431 B123639 CHG 003

Received @ Dart February 19, 2015
Inspected@ Dart March 13, 2015

CUSTOMER: HAWKER PACIFIC
CUSTOMER CONTACT: SCOTT STODDART
SHIPPED FROM: NEW SOUTH WALES, AU

Instructions for RA111954 D350-607-431 B123639

- Two kits were inspected
- Kit one is complete and good to be stock with new batch number and paper work
- Kit two has been open with some parts used
- List of used parts that will be scrap, and replace with new ones
 - AN4-14A
 - AN4-42A
 - AN6-13A
 - MS21042L4
 - MS21042L6
 - NAS1149F0432P
 - NAS1149F0663P
- List of parts that was return and need to be added to complete kit
 - D4775-041 B121856 2x
 - D3501-1 B123723 8x
 - D3910-5 B117637 1x
 - D3910-7 B120673 1x
 - D3984-030 B123577 8x
 - D4776-3 B116908 2x
 - D4917-300 B115925 1x
 - D4917-310 B115020 1x
 - D4917-332 B112446 1x
 - D4917-320 B112209 1x
 - D4917-315 B112251 1x
- Return completed kit in stock with new batch number and paper work
- D2126-072 B110652 and B110653 was return and can be re-stock

130547.

Time Estimate : 4 hour

Departments Required: Quality, stores

Pictures Attached : N/A

QTY INSPECTED : 2x D350-607-431 B123639 CHG 003

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																																																						
OTHER : _____																																																																									

25.27.9 D350-607-641/-611 LONG CARGO TUBE PARTS LIST

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 003 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT
		8	8	D3501-1	BUSHING
		2	2	D3910-3	X-TUBE LUG
		2	2	D3910-5	X-TUBE LUG
1			//	D3912-041	EYEBOLT RECEIVER ASSY
4				D3917-3	WASHER
		8	4	D3984-030	RUBBER EXTRUSION, X-TUBE
		1		D4148-041	FWD X-TUBE LUG ASSY
		1		D4149-041	AFT X-TUBE LUG ASSY
1				D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
		2	2	D4775-041	STRUT ASSEMBLY
		2	2	D4776-3	SKIDTUBE CLEVIS
1				D4874-041	CARGO TUBE ASSEMBLY
1				D4875-5	CARGO TUBE AFT STRUT
1				D4875-045	FWD ATTACHMENT CLEVIS
			1	D4917-300	PLACARD MAX LOAD
			1	D4917-310	PLACARD MAX LOAD
			1	D4917-315	PLACARD, MAX LOAD
			1	D4917-320	PLACARD, MAX LOAD
			1	D4917-332	PLACARD, MAX LOAD
1				D5028-041	PLUG ASSEMBLY
1				D5031-041	LOCK PIN ASSEMBLY
2				AN310-4	CASTLE NUT
2				AN4-11	BOLT
4				AN4-13A	BOLT
		20	12	AN4-14A	BOLT
		4	4	AN4-42A	BOLT
		2	2	AN6-13A	BOLT
4	24	16		MS21042L4	NUT
		2	2	MS21042L6	NUT
	2			MS24665-151	COTTER PIN
20	40	24		NAS1149F0432P	WASHER
	4	4		NAS1149F0663P	WASHER

3910-7

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/04/05/06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	